

Date: Thursday, 11/29/2007 11:01:10 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GASKET	
Job Number	36018				
Estimate Number	10767				
P.O. Number	N/A		Part Number	D32457	
This Issue	11/29/2007	S.O. No.	Drawing Number	D3245 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	Drawing Revision	B	
Previous Run	35668		Material	N/A	
Written By			Due Date	12/5/2007	Qty: 10 Um: Each
Checked & Approved By	<i>HB 07/11/29</i>				
Comment	Est C 04.11.17 Made in-house KJ/JLM Est Rev:b ECN 1052 07-10-31 DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3245	Gasket <i>14</i>
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) GASKET Batch: <i>B3S607 HB 07-12-6</i>		
2.0	WATER JET	FLOW WATER JET <i>14</i>
Comment: FLOW WATER JET 1-Cut as per Dwg D3245 Dwg Rev: <i>B</i> HB 07-12-6 Prog Rev: <i>B</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 07-12-6</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK <i>5 07/12/06</i> <i>x14</i> <i>coules</i>
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>ST 79</i> <i>A DS 07/12/07</i> <i>x14</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 79 A DS 07/12/07</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:01:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 36018

Part Number: D32457

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

11/29/07

Job Completion



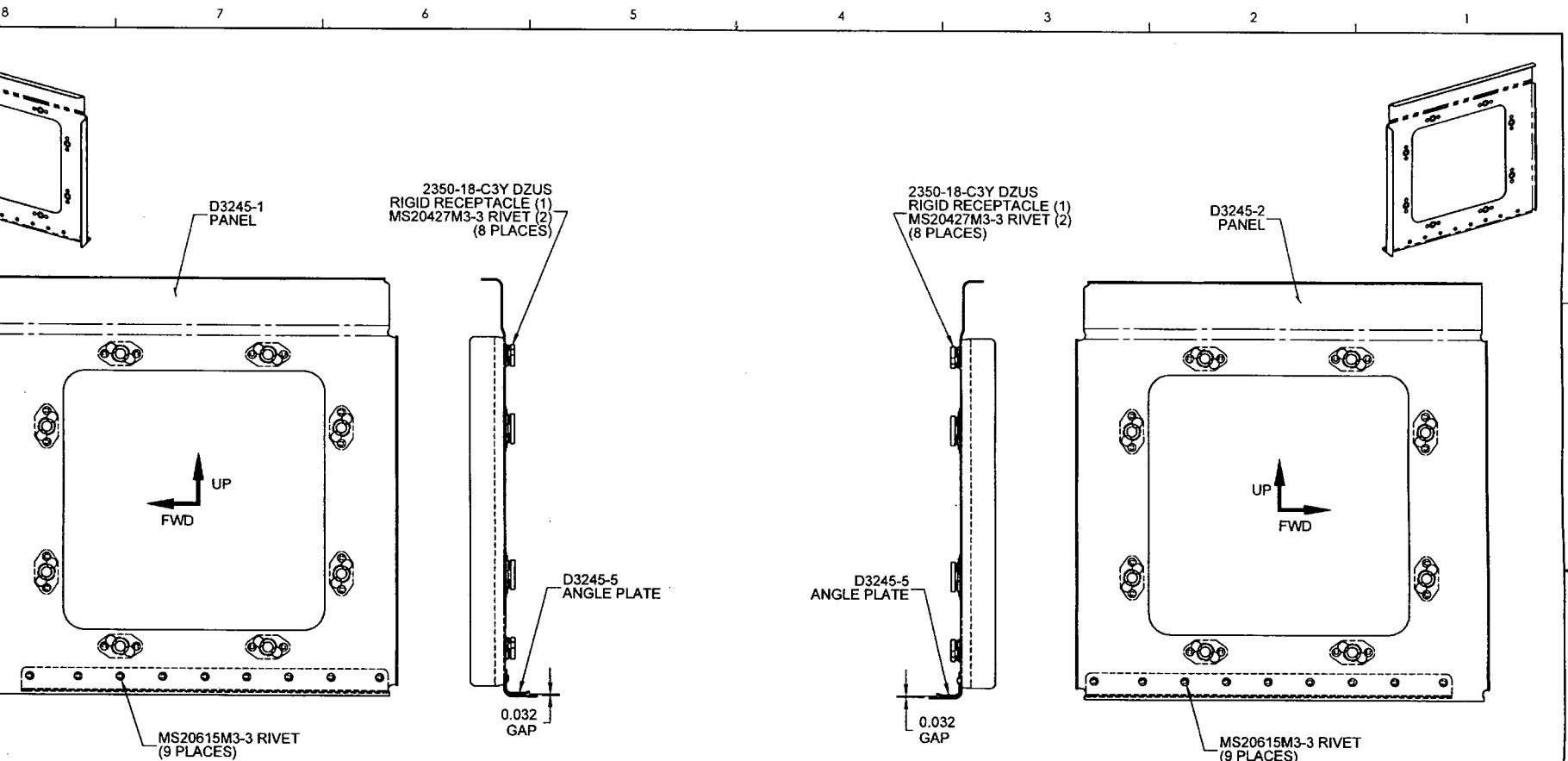
W 11/29/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
		D3245-042	ACCESS PANEL ASSEMBLY, RH
1	1	D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

D3245-042 ACCESS PANEL ASSEMBLY

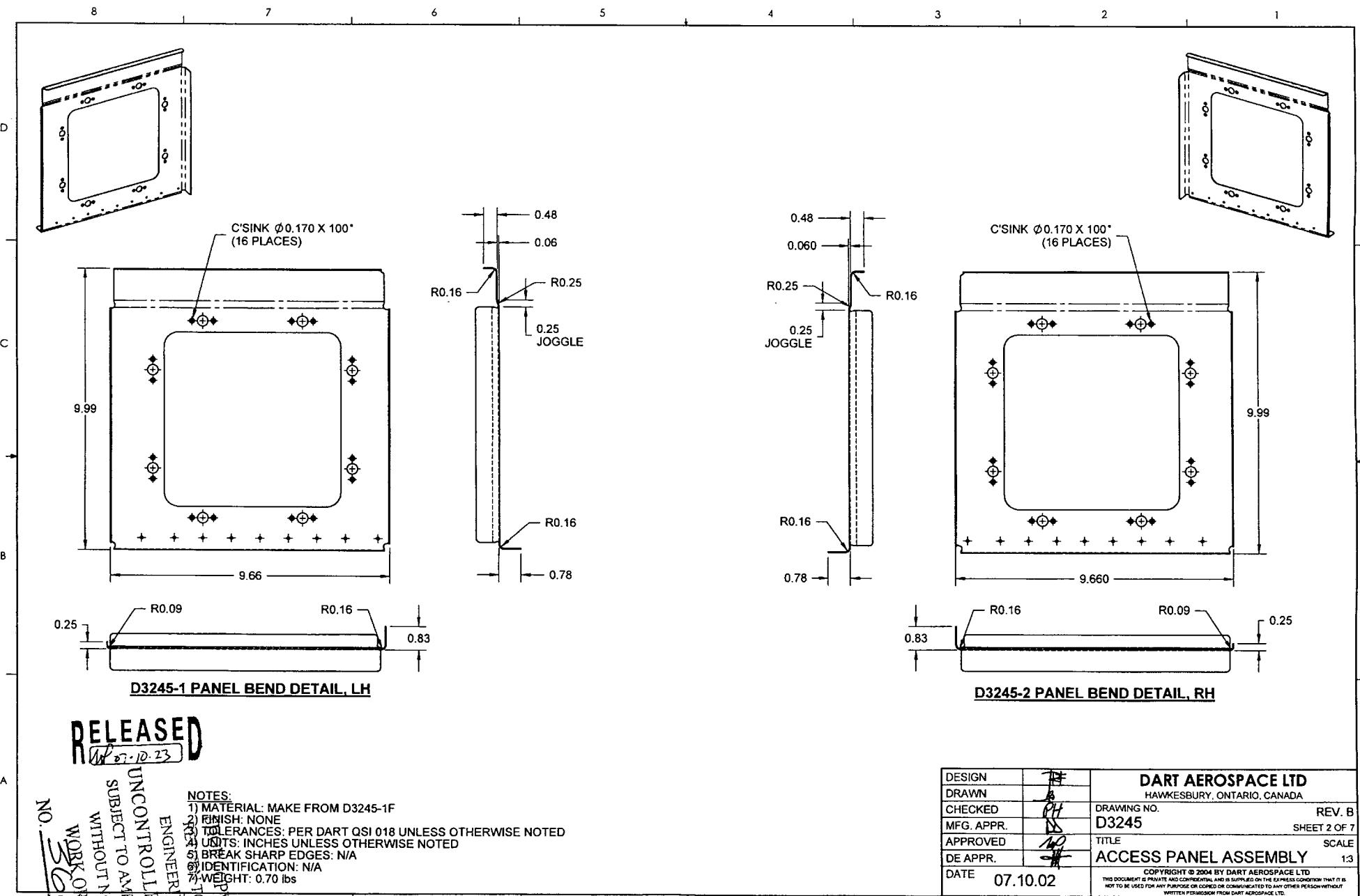
B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION		
DESIGN	74	DART AEROSPACE LTD	
DRAWN	74	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	D3245
MFG. APPR.	DA	REV. B	SHEET 1 OF 7
APPROVED	100	TITLE	SCALE
DE APPR.	100	ACCESS PANEL ASSEMBLY	
DATE	07.10.02	1:2.5	

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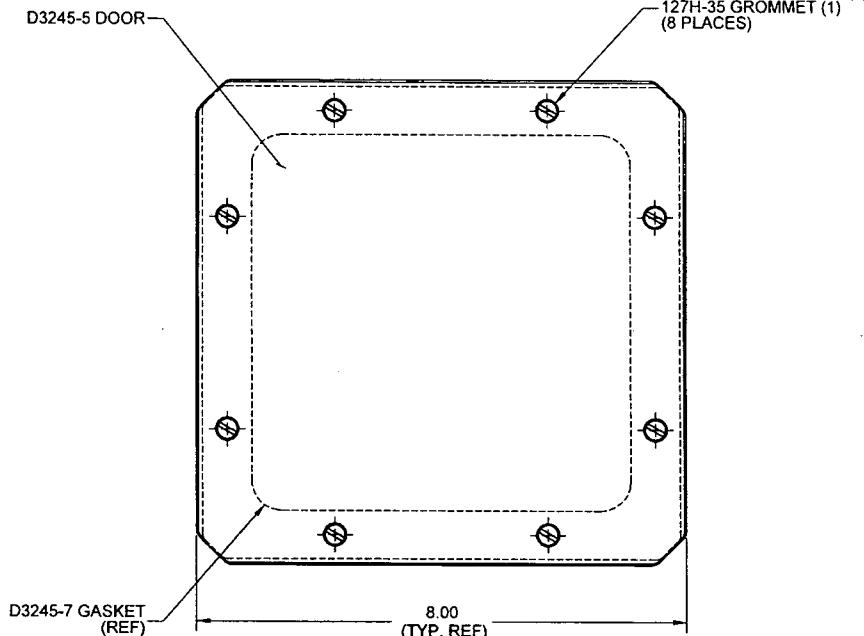
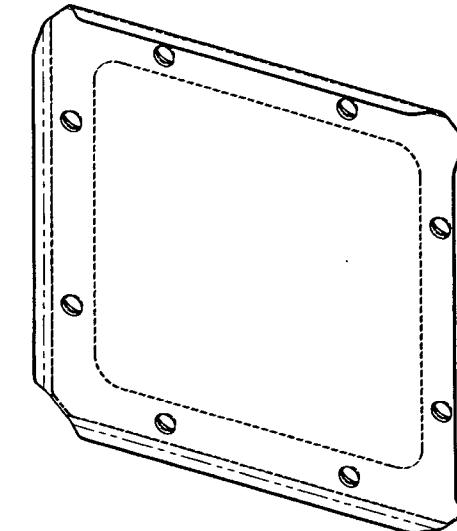
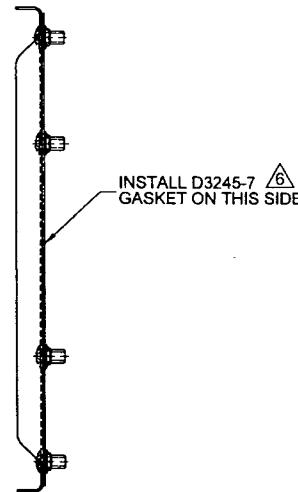
RELEASED
07.10.02

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXX" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.83 lbs

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WITHOUT NOTICE
WORK ORDER NO. 26013
ENGINEERING



8 7 6 5 4 3 2 1

**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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27.10.02

A
NO.
105
WORK ORDER 18
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DESIGN	11	DART AEROSPACE LTD	
DRAWN	b	HAWKESBURY, ONTARIO, CANADA	
CHECKED	pH	REV. B	
MFG. APPR.	n	DRAWING NO. D3245 SHEET 3 OF 7	
APPROVED	m	TITLE	
DE APPR.	s	SCALE	
DATE	07.10.02	ACCESS PANEL ASSEMBLY 1.2	

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D

D

C

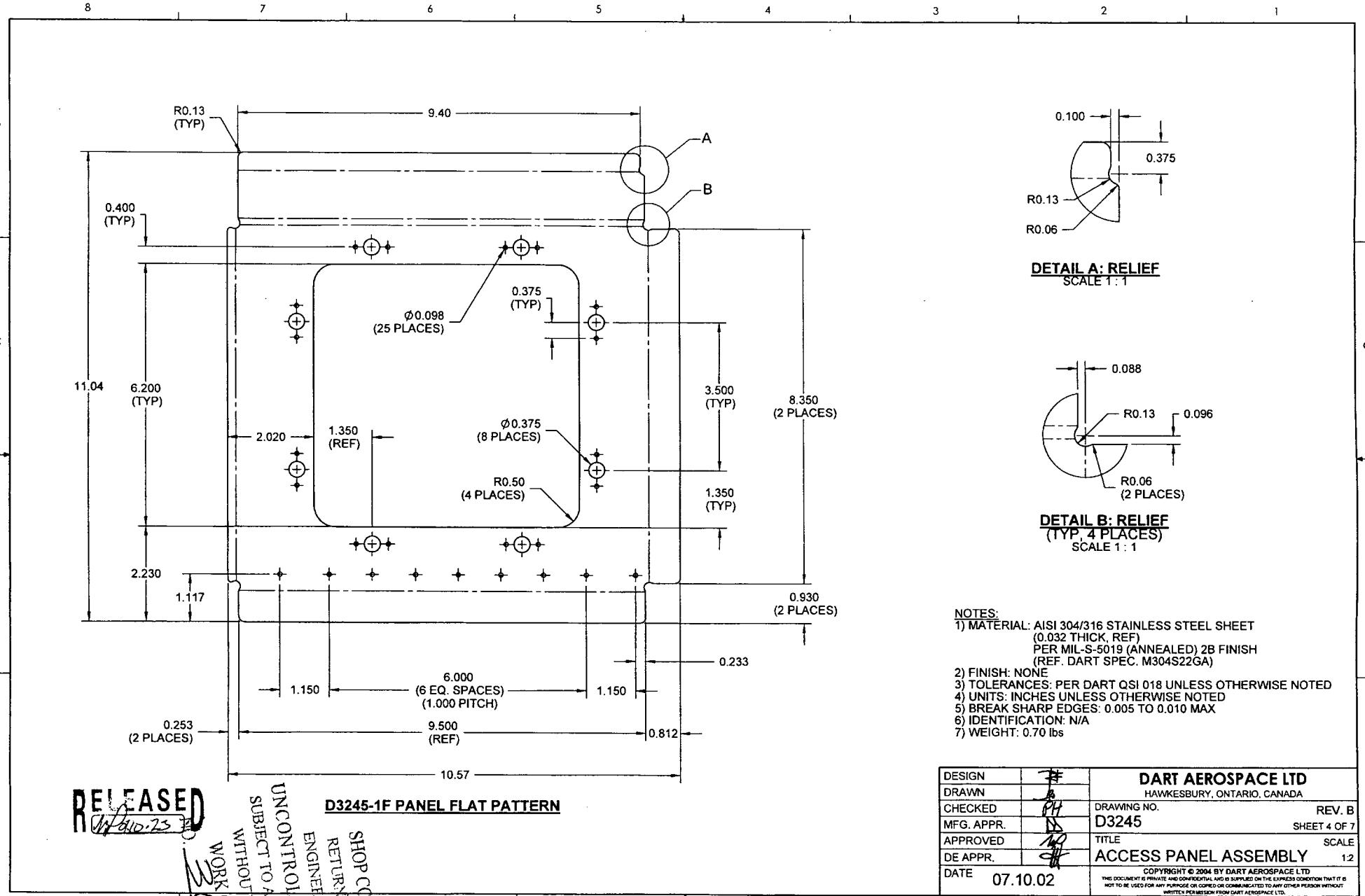
C

B

B

A

A



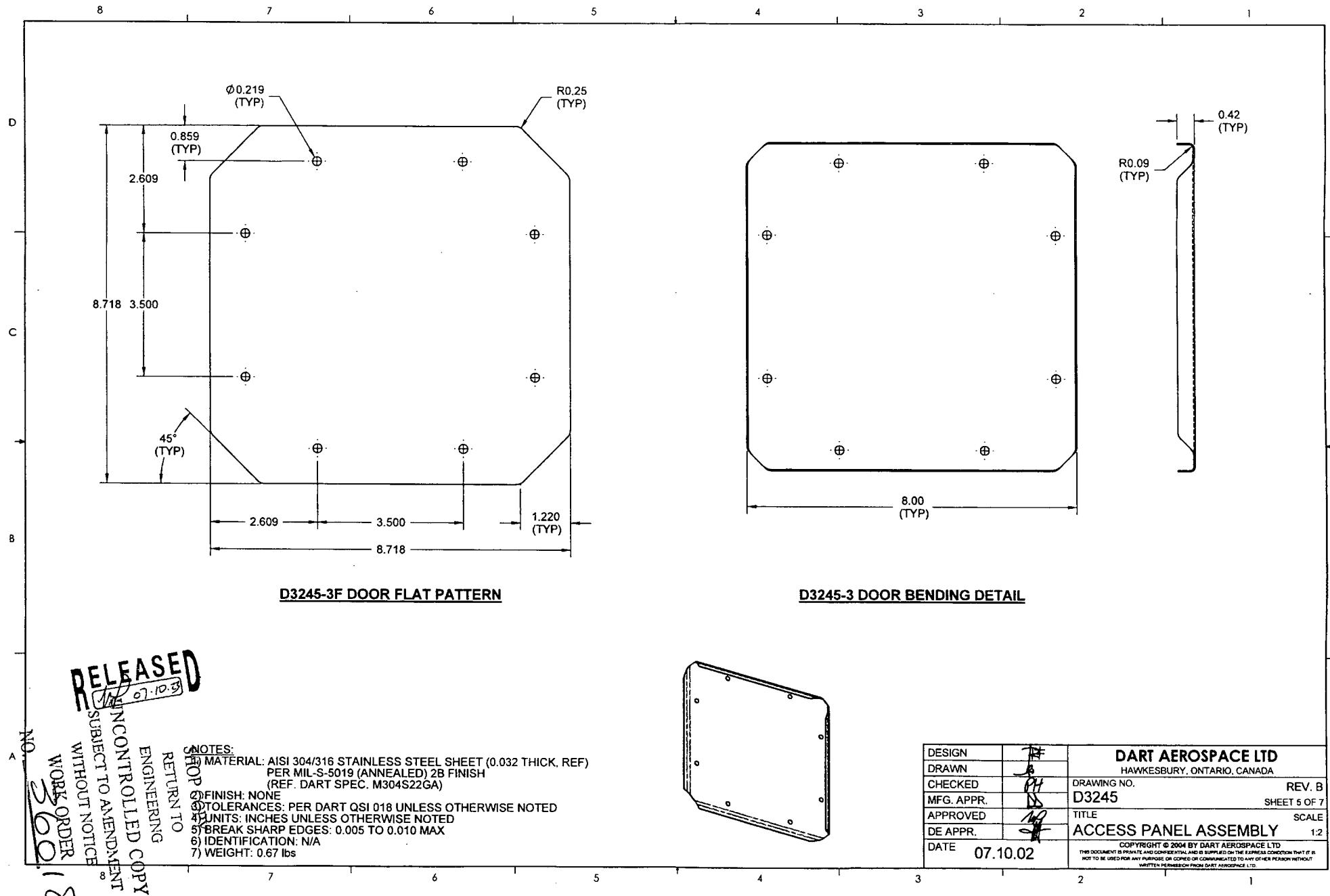
RELEASED
MAY 10, 2023

D3245

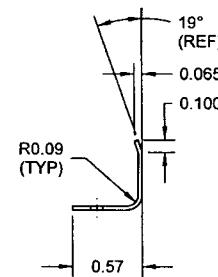
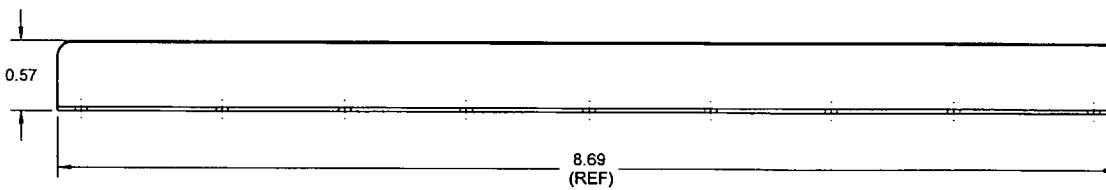
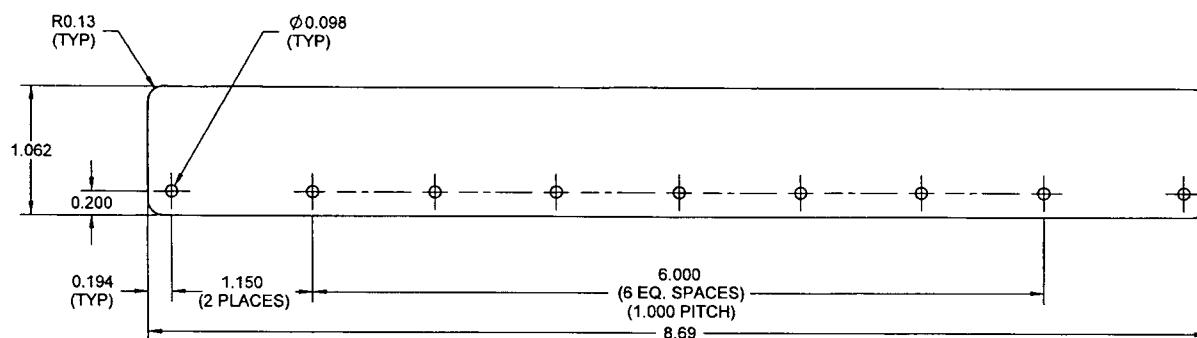
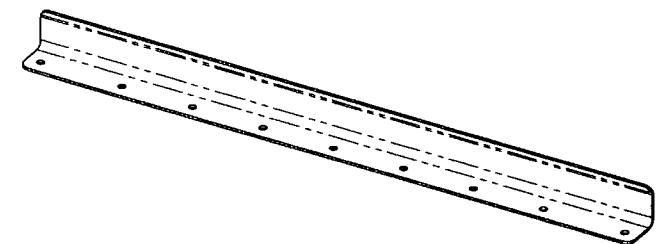
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RETURN TO	SUBJECT TO AMENDMENT
ENGINEERING	NOTICE
WITHOUT	WORK ORDER
36018	

D3245-1F PANEL FLAT PATTERN

DESIGN	<u>F</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<u>B</u>			
CHECKED	<u>PY</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DK</u>	D3245	SHEET 4 OF 7	
APPROVED	<u>AS</u>	TITLE	SCALE	
DE APPR.	<u>ST</u>	ACCESS PANEL ASSEMBLY		
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8 7 6 5 4 3 2 1



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07.10.02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

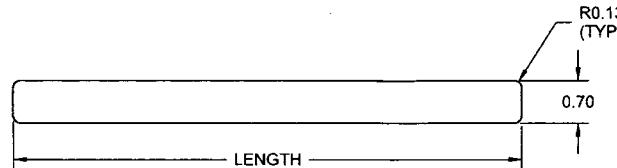
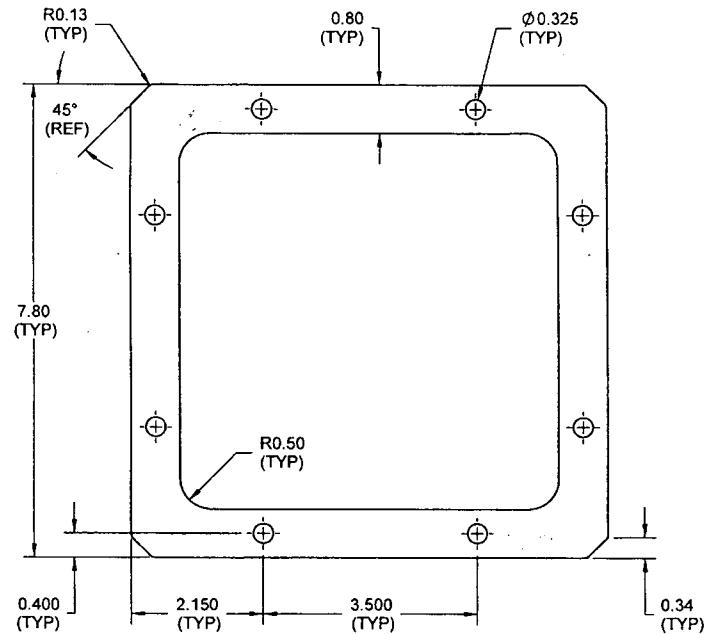
NO. 3601
WORK ORDER 8
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IN CONTROLLED COPY
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DESIGN	<u>PF</u>	DART AEROSPACE LTD
DRAWN	<u>b</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>PH</u>	DRAWING NO.
MFG. APPR.	<u>NA</u>	D3245
APPROVED	<u>AP</u>	REV. B
DE APPR.	<u>NA</u>	SHEET 6 OF 7
DATE	07.10.02	TITLE
		SCALE
		ACCESS PANEL ASSEMBLY
		1:1

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A

8 7 6 5 4 3 2 1

**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.02

NO. 3600
 WORK ORDER 18
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 ENGINEERING
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 SHOP COPY

NOTES:
 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

DESIGN	<u>PF</u>	DART AEROSPACE LTD	
DRAWN	<u>b</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	D3245
MFG. APPR.	<u>ND</u>	REV. B	SHEET 7 OF 7
APPROVED	<u>NP</u>	TITLE	ACCESS PANEL ASSEMBLY
DE APPR.	<u>SH</u>	SCALE	1:2
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DART AEROSPACE LTD	Work Order:	36018
Description: GASKET	Part Number:	D3245-7
Inspection Dwg: D3245-7 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	H3	Audited by:	J	Prototype Approval:	N/A
Date:	07-12-6	Date:	7/12/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	